

Work Order ID 62883

Tuesday, October 12, 2010 1:02:12 PM

Page 1

Item ID: D205-634-041

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 10/13/2010 Start Qty: 1.00

Required Date: 10/29/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: umf Date: 10-10-12 Tooling:

QC: Date: SPC (Y/N):

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

Splu/11

HJ for CL 10-11-10

110

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

[Handwritten signature]

10-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove marks bending marks

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

(X1)

BB
10/10/20

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 - PE 10/10/20

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: Date: Tooling:

QC: Date: SPC (Y/N):

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

M1115778

BE 10/10/21

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

M1115778

BE 10/10/21

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

10-10-21

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-041 PAR #: _____ Fault Category: Skid tube NCR: Yes No DQA: _____ Date: 10/10/22
 Resolution: rework Disposition: rework QA: N/C Closed: UK Date: 10/11/22

NCR: <u>62883</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10/22	140	upon inspection, it was noticed that the aft saddle holes are not perpendicular to each other & off close to 0.060" \Rightarrow 0.080", when the inspection saddles are installed. x-bolts possibly	<u>JS/14/2</u>	remove & re-work aft saddle x-bolt spacer location. <u>D2579 Qty 4 B61199</u> <u>Alum Rod M 115228</u>	<u>DD</u> 10-10-22 <u>BE</u> 10-10-22	<u>6</u> 10/14/21	<u>JS/14/2</u>	<u>10/10/22</u>
		pulled to 1 side when stacked & welded	<u>JS/14/2</u>					
		R.e. process.	<u>JS/14/2</u>					

NOTE: Date & initial all entries

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Start Date: 10/13/2010 Start Qty: 1.00

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Required Date: 10/29/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

7 H 10/11/02 - 1' /

W/O:		WORK ORDER CHANGES					
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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



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Start Date: 10/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 11:50 291

Memo

0.00

START TIME: *11:20*
OVEN TEMPERATURE: *320°*
FINISH TIME: *11:50*

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

*Solutlog**① 10-11-2*

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Hand Finishing

Memo

0.00

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 11/15/10

Sikaflex expire date: 10/6/11

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 11/15/10

Sikaflex expire date: 11/6/11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 11/15/10 790

= J

10/11/09

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D205-634-041

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Setup Start

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Stop

Item Name: Replacement Skidtube

Start Date: 10/13/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

Soluter



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

40

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: 78

PPP Rev: 1

10/11/12

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/12

WLF
10-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

623 52
53

Picklist Print

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Work Order ID: 62883



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 10/13/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by: DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2580-1		Manufactured	No			110	Each	3.0000	1	1			



205 Skidtube bent detail



Location	Loc Qty	Loc Code
LG	2	①
62047	1	
62048	1	
ST046	1	
59856	1	

DP 10-10-19

D2576-3

Manufactured No

140

Each

68.0000

1

1



Step (maching detail)



Location	Loc Qty	Loc Code
LG	68	
46661	20	
52215	48	

BE 10-10-21

38
40
83

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 62883

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 10/13/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 144.0000 20 20



Crossbolt Spacer

Location Loc Qty Loc Code

LG	144	
57052	5	
57348	4	
58433	2	
59113	7	
60845	1	
61199	125	



20 BE 10/10/21

D2855 Manufactured No 200 Each 59.0000 1 1



Cap

Location Loc Qty Loc Code

FP6	1	
56613	1	
ST026	58	
50513	1	
50770	28	
51539	2	
53791	27	



363634

10/11/08

AN3-5A Purchased No 200 Each 1,447.000 2 2



Bolt

Location Loc Qty Loc Code

ST350	1447	
105057	447	
115016	500	
115371	500	



10/11/08

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Shop Packet Print

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Work Order ID: 62883

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Parent Item Name: Replacement Skidtube

Start Date: 10/13/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No

200

Each

0.0000

2

2



M114884



X2 YL 10/14/08

Washer

ALS7-1032-130 Purchased No

200

Each

1,746.000

50

50



YL 10/14/08

Insert

Location

Loc Qty

Loc Code

FP

729

M115911

Y50

115079

729

ST282

1017

113238

17

115502

500

115581

500

AN3C4A Purchased No

200

Each

1,511.000

50

50



YL 10/11/08

BOLT

Location

Loc Qty

Loc Code

ST245

20

110139

20

ST303

3

115438

3

ST350

1488

114108

14

114416

12

114523

2

115300

460

115589

1000

Y50

W/O:		WORK ORDER CHANGES					
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Start Date: 10/13/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

200 Each 29.0000 50 50



washer



10/11/08

Location

Loc Qty

Loc Code

ST245

29

107534

29

M115832

x50

D3566-13 Manufactured No

200 Each 34.0000 1



Gasket



10/11/08

Location

Loc Qty

Loc Code

FP012

34

60209

8

x1

61996

26

D3566-5 Manufactured No

200 Each 20.0000 1



Gasket



10/11/08

Location

Loc Qty

Loc Code

FP

8

60869

8

x1

FP015

12

62463

12

D3566-1 Manufactured No

200 Each 9.0000 2



Gasket



10/11/08

Location

Loc Qty

Loc Code

FP015

9

57715

2

B62892

x2

61992

7

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Start Date: 10/13/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

22.0000

1

1



Wearshoe



Al velulo

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

8

57525

1

58709

1

61699

6

FP-19

13

62237

13

X1

D2594-3

Manufactured No

200

Each

899.0000

16

16



O-Ring, 205 Skidtube



Al 10/11/08

Location

Loc Qty

Loc Code

FP

43

55546

19

58191

12

59358

12

fpa

856

61762

856

B62893

B61

X 16

D2594-1

Manufactured No

200

Each

235.0000

16

16



Plug, 205 Skidtube



Al 10/11/08

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

52

58434

15

61932

37

B61862

B62893

X16

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DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

#62883
RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

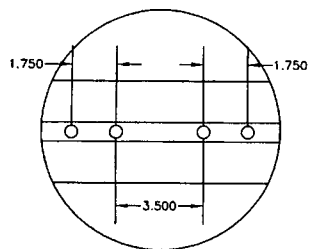
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

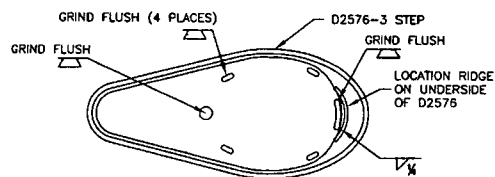
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

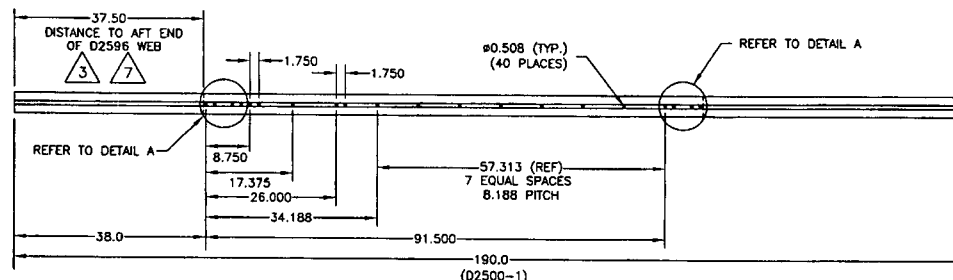
DETAIL A
SCALE 5:24



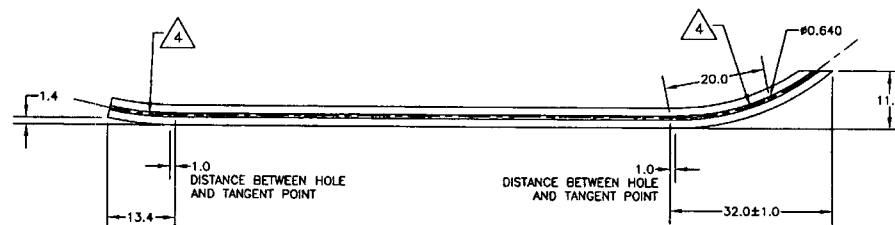
DETAIL B
SCALE 5:24



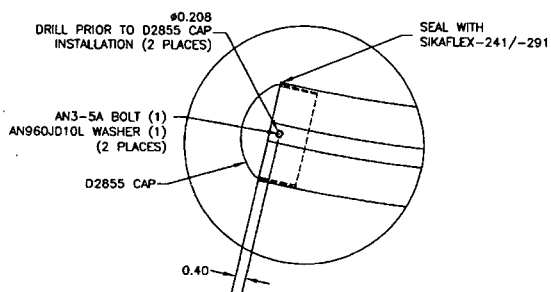
D2580-1 DRILLING DETAIL



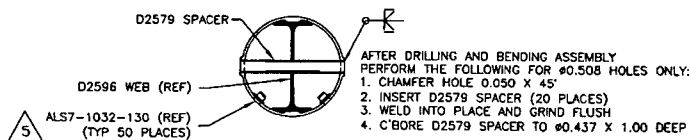
D2580-1 BENDING AND CUTTING DETAIL



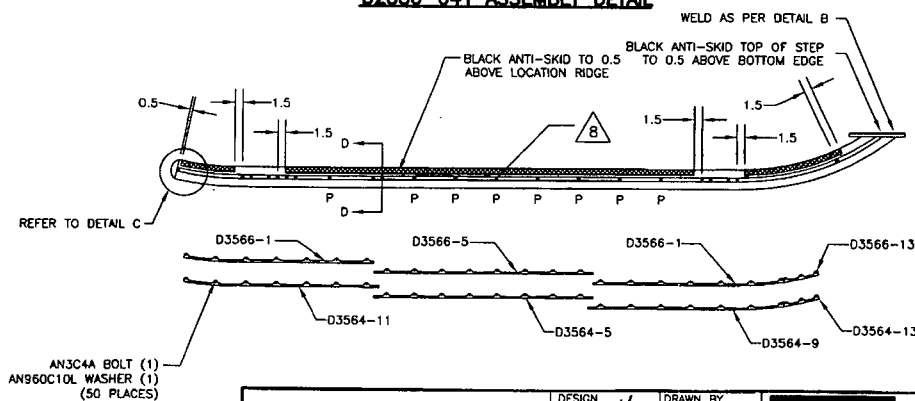
DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	TITLE	D2580	SHEET 2 OF 3
07.02.27	205 SKIDTUBE ASSEMBLY	SCALE	1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07 Dec 78

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating the rear view of the engine cover assembly. The diagram shows the installation of the D2855 cap and seal. The following components and dimensions are labeled:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- SEAL WITH SIKAFLEX-241/-291
- AN3-SA BOLT (1)
- AN960JD10L WASHER (1)
- (2 PLACES)
- D2855 CAP
- SEE NOTE ii)
- 0.40

Diagram illustrating the assembly of a wheel component. The diagram shows a cross-section of a wheel with a central hub and spokes. The components are labeled as follows:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

Assembly steps are listed on the right:

1. CHA
2. INS
3. WE
4. C'B

After performing these steps, the wheel is shown in its final assembled state.

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. #B0RE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

[illegible]

(MAKE FROM D2580-1 DRILLING DETAIL)

5.985

5.338 (REF)

51.340

39.580

5.915

4

20.0

11

1.4

1.0

1.0

32.0 ± 1.0

13.4

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

1.0 DISTANCE BETWEEN HOLE AND TANGENT POINT

Ø0.508 (8 PLACES)

Ø0.640

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE NO PLUG

0.5

1.5

1.5

H

8

1.5

1.5

1.5

NO C'BORE NO PLUG

P P P P P P P P

H

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

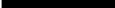
AN980C10L WASHER (1)

(50 PLACES)

DESIGN

DRAWN BY

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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	 DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 240

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berley Elliott
Job number: 62176
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. P. Date of Test Coupon 10.09.30
Welder Berley Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld